

Date: Monday, 11/27/2006 8:36:20 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEBBING TIDY		
Job Number	: 29694					
Estimate Number	: 11381					
P.O. Number	: N/A			Part Number	: D32153	
This Issue	: 11/27/2006		S.O. No. : N/A	Drawing Number	: D3215 REV C	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : SMALL /MED FAB	Drawing Revision	: C	
Previous Run	: 29139			Material	: N/A	
Written By	: <u> </u>			Due Date	: 11/30/2006	
Checked & Approved By	: _____			Qty:	8 Um: Each	
Comment	: Est. A04.01.06 New issue KJ/RF Est Rev:B Now on Waterjet 06-07-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
		Comment: Qty.: 0.0271 sf(s)/Unit Total : 0.2167 sf(s) 5052-H32 .040 Sheet Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify for D3215-3A Batch: <u>M102723</u> <u>06/11/27</u>	(8)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3215 Dwg Rev: <u>C</u> <u>M</u> <u>06/11/27</u> Prog Rev: <u>C</u>	(8)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	(8)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>M106/11/27</u> (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/27/2006 8:36:20 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 29694

Part Number: D32153

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0084 sf(s)/Unit Total: 0.0672 sf(s)

5052-H32 .040 Sheet

Batch: M102448

ml

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut blank: 2.130" x 0.530"

ml 06/11/29

2-Deburr

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SB 06/11/29

8

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/29 ⑧

8

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

A/R AL ROD BATCH: M102421

GPC 06-11-29

Identify as D3215-3

Grind flush

11.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/11/29 ⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/27/2006 8:36:20 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 29694

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Mo 06/11/29 ⑧

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Yl a.m 06/11/29

14.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06/11/30 ⑧x

15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 06/11/30 ⑧

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

C 06/11/30 ⑧

17.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

11 06/11/30 ⑧

Job Completion



C 06/11/30

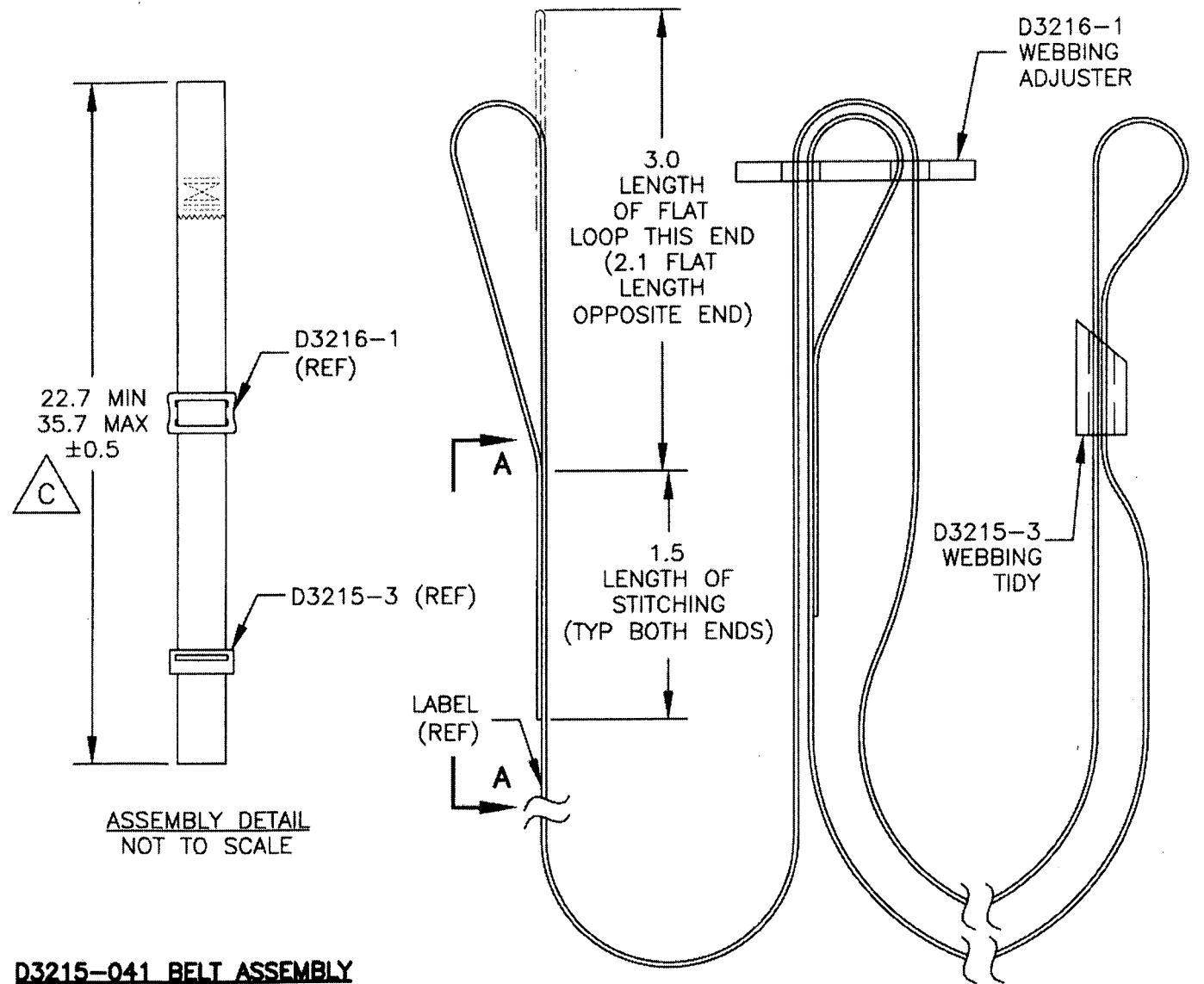
REFERENCE ONLY

DART

© COPY ISSUE DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3215	SHEET 1 OF 3
DATE	TITLE		
04.03.05	BELT ASSEMBLY		
		SCALE	NTS
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	

RELEASED
04.03.05



D3215-041 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED
TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

REFERENCE ONLY

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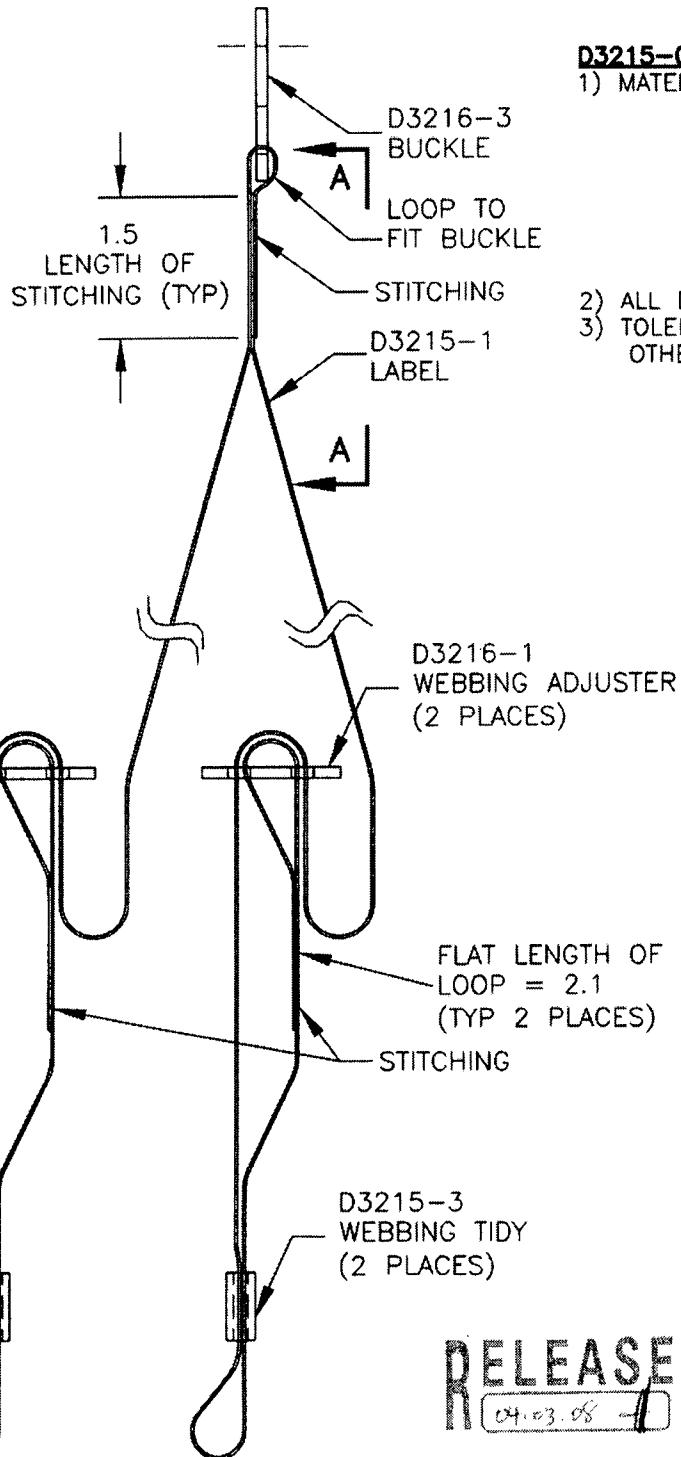
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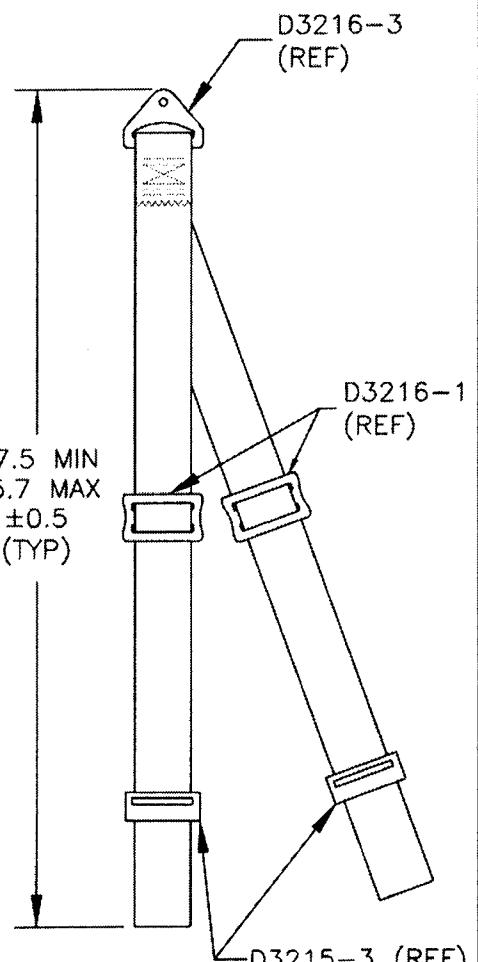
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3215
DATE	TITLE	REV. C SHEET 2 OF 3 SCALE NTS

04.03.05



D3215-043 BELT ASSEMBLY

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472 (2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN)
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



RELEASED
04.03.05

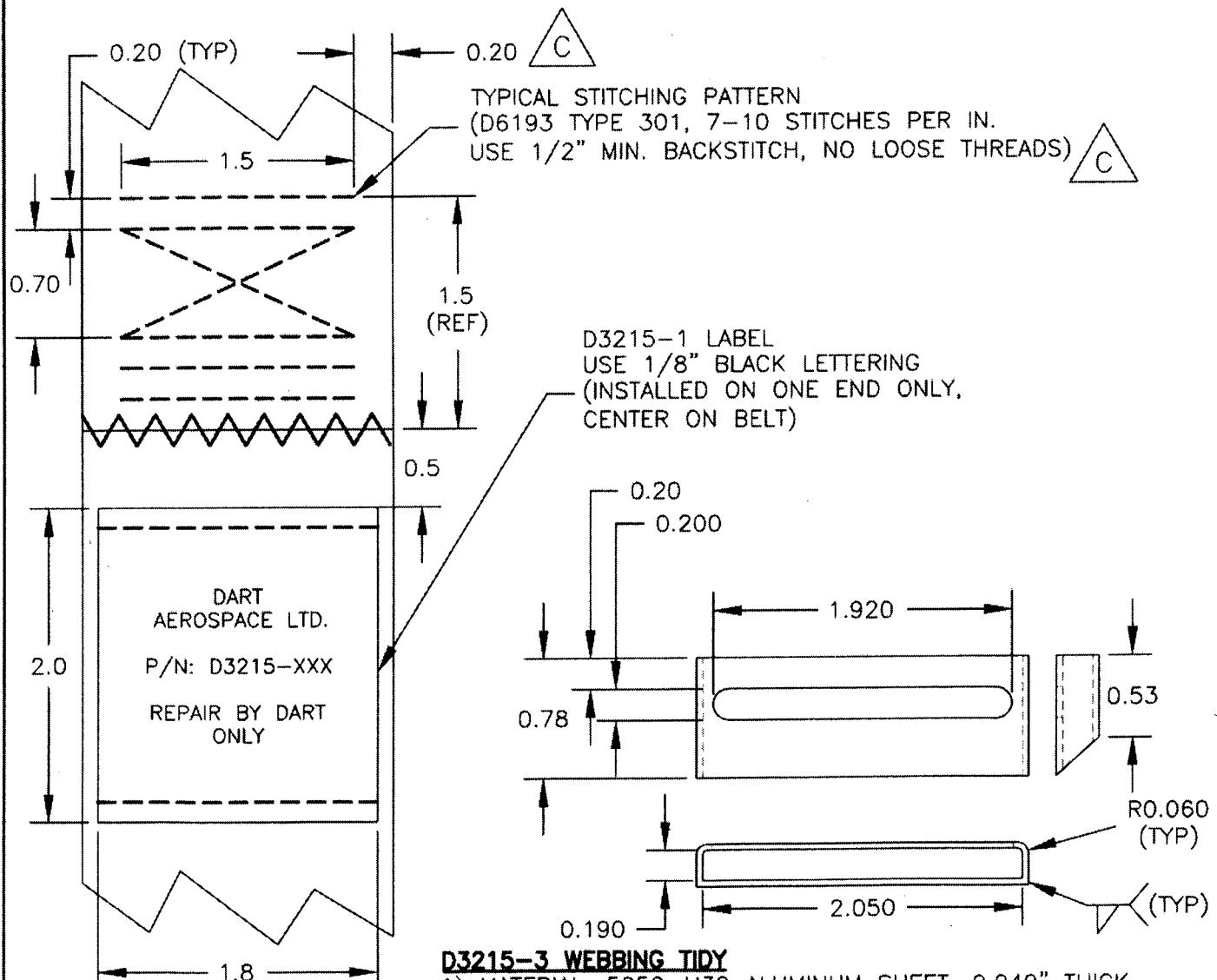
ASSEMBLY DETAIL
NOT TO SCALE



DESIGN	EP	DRAWN BY	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3215 REV. C SHEET 3 OF 3
DATE	04.03.05			TITLE HARNESS ASSEMBLY SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043



D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
 (REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
 DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED

RELEASED
 04.03.05

DART AEROSPACE LTD

Work Order:

296.94

Description: Webbing tidy

Part Number:

D3215-3

Inspection Dwg: D2215 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:

ad: m

Audited by:

Prototype Approval:

Date:

8/11/27

Date: _____

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	